

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:27:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 35671

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2944

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2944

Support

B 34004 = 4
B 35689 = 16

SE 01.11.29 10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/R Aluminum Rod M105058
M105844

3-Grind End Cap welds flush

Q.M

07.12.03

10

SE 01.11.29 10

SE 07.11.29 10

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Q.M 07.12.03 10

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q.M 07.12.03 10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M

07.12.03

10

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/12/04 10

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: M105058

Q.M 07.12.04 10

SE 07.12.04 10

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Job Number: 35671

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FD 07-12-06 (10)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/12/06 (10)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

FL 07/12/06 (10)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105914

M-1 07/12/06 (10X)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2946 and QSI 005 4.4

m 105030

FL 07/12/06 (10)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

7/12/06 SP

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

20.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Mounting Lug

Batch:

B 32163 27X 33250 13X

07/12/06 (10)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT MAINTENACE STEP

Job Number: 35671

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Mounting Lug

Batch: B35470

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2606 f(s)/Unit Total : 12.6063 f(s)

Abrasion Strip 7.20" long x2

Batch: 34642

23.0

D2945

Step Mounting Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Step Mounting Plate

Batch: 29914

7X

B35690

3X

24.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Batch: M102140

25.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M103947

7X

M104214

33X

26.0

AN414A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Batch: M102473

67X

M105653

13X

Ce 7/12/10 (10)

27.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 140.0000 Each(s)

Washer

Batch: M105906

Ce 7/12/7 (10)

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT MAINTENANCE STEP

Job Number: 35671

Part Number: D350591133

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L4

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total : 140.0000 Each(s)

Nut

Batch: M105054

PC 1/12/7 (10)

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 01/12/10 (210)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location:

PPP Rev:

A

7/12/10 SD (10X)

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)
D07/12/11

Job Completion



min 2007/12/11
u

W/O:		WORK ORDER CHANGES					
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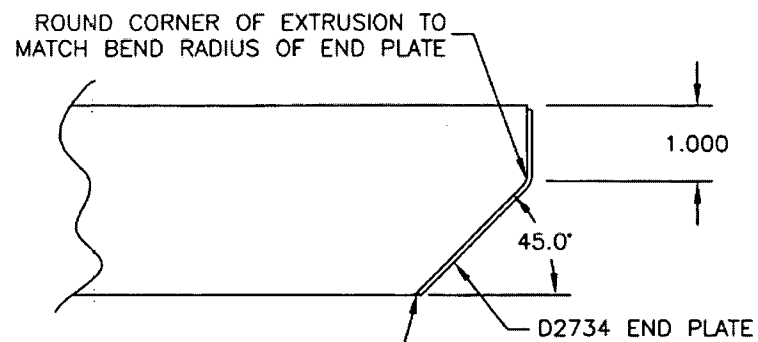


D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

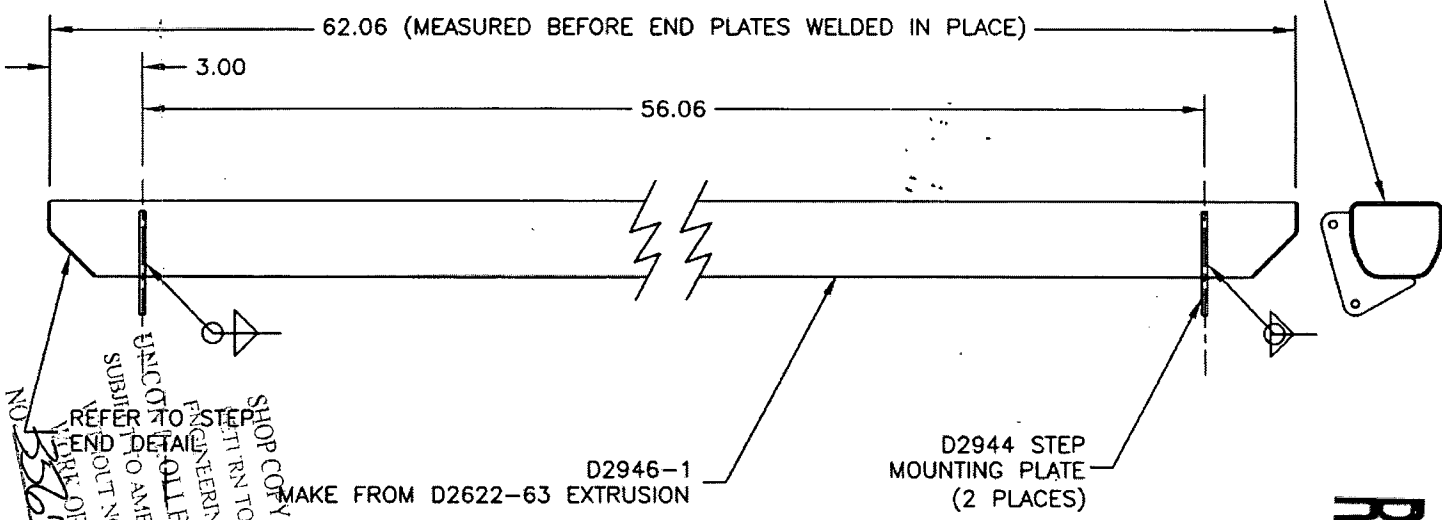
*cut per drawing

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-28

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2946
DATE	05.11.14	TITLE	STEP ASSEMBLY	REV. B
A	99.12.13	NEW ISSUE		SHEET 1 OF 1
B	05.11.14	UPDATE FINISHING NOTE		SCALE 1:6

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